

Work Order ID 71443

Monday, July 04, 2011 1:04:30 PM



Page 1

Item ID: D4155-1

Accept



Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 7/5/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-07-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4155	B

100

0.00



Cold Saw

Memo

0.00

11/07/14

8

Hyd Mech

Cut blanks at 91.75"

110

0.00



HAAS 1

Memo

0.00

11/07/14

8

HAAS CNC vertical machine #1

1-Mill as per folio E0048 & dwg D4155,

FOLIO REV: _____

DWG REV: _____

2-Deburr as required

Manual Mill

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Run Start



Stop



Sequence ID/
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Set Up/
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Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/07/14

8

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/07/14

8

0

140

0.00



Small Fab

Memo

0.00

Small Fab

Grind off chamfer on fwd end of bar as per dwg

11/07/14

8

W/O:		WORK ORDER CHANGES					
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Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5 w/o's

(ED)

160

Identify as per dwg & Stock Location: *w/a*

0.00



Packaging

Memo

0.00

Packaging

12 11-7-18 (28)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/18

11-07-18

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Picklist Print

Monday, July 04, 2011 1:04:28 PM

Page 1

Work Order ID: 71443



Parent Item: D4155-1



Parent Item Name: Bar

Start Date: 7/5/2011



Required Date: 7/19/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC
11.04.14 as per dwg revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 		Purchased	No			100	f	322.1147	7.6333	64.28042			
304 BAR .250 x .500													

Location

Loc Qty

Loc Code

MAT006

221

116148

78

117842

143

MAT050

101.1147

117176

101.1147

64.5 *JS* 11/07/14

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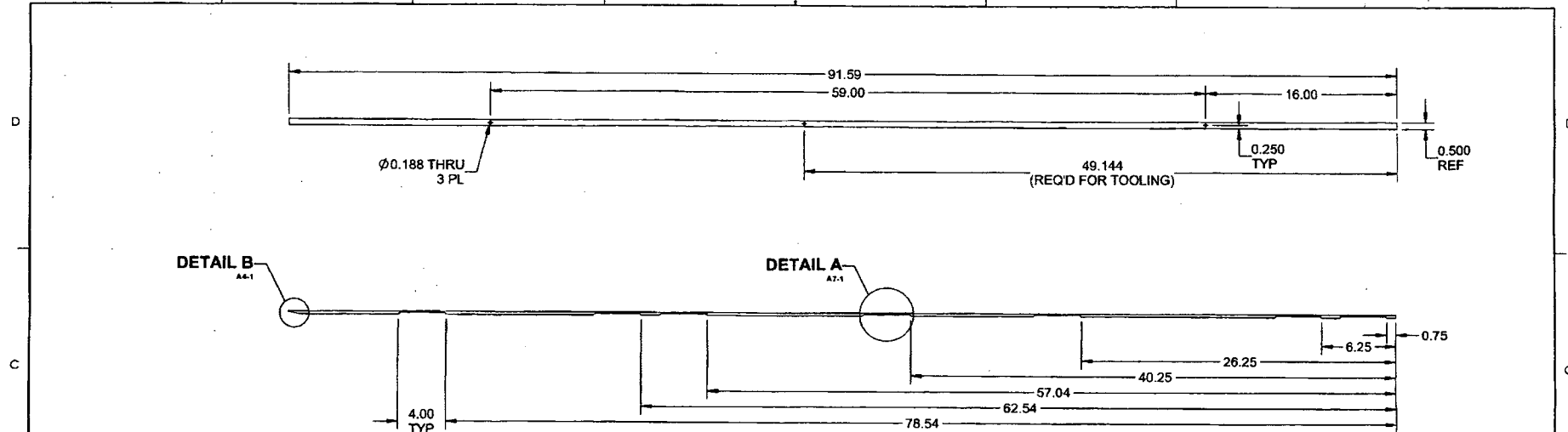
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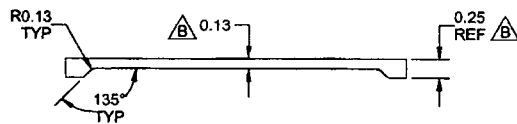
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8 7 6 5 4 3 2 1

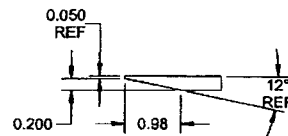


D4155-1 BAR

71443



DETAIL A
SCALE 2X, TYP



DETAIL B
SCALE 2X

RELEASED
2011-04-13

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X00.500
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.82 lbs

B	CHANGED MANUFACTURING PROCESS: MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SK	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	CP		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.		D4155	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	11.04.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

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